

Work Order ID 86084

June-20-12 12:57:19 PM

86084

Page 1

Item ID: D2125

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 350/355 Floor Window

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2125

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

2 0 Jun 12-6-24

FLOW CNC Waterjet

1-Cut as per Dwg D2125 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

Poly Case 1/8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

2 0 Jun 12-6-24

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

x 2 17/07/03

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Thermoform

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

x2

12/02/08

170

170

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

5/10/04

2

180

180

Packaging

Packaging

0.00

Memo

0.00

Packaging

Wrap in cellophaneIdentify and StockLocation:

208

2x

SP
12-7-5

W/O:		WORK ORDER CHANGES					
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Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

CK 12/7/10

ME 12-07-05

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Picklist Print

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Page 1

Work Order ID: 86084

86084

Parent Item: D2125

D2125

Parent Item Name: 350/355 Floor Window

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D05.10.14 Added bold comments on step 5/6 & cellophane on step 7KJ/EC

IPP E 07.05.29 thermoformed in-house EC

IPP F 07.09.28 rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			120	sf	287.2590	1.664	3.503158			

MACRLICS 125

1/8" Polycast II Sheet

**

Jm 12-6-2

Location

Loc Qty

Loc Code

MAT019

287.259

110633

3

117324

0.2467

117431

10.7967

119591

48.22

121850

224.9956

19951

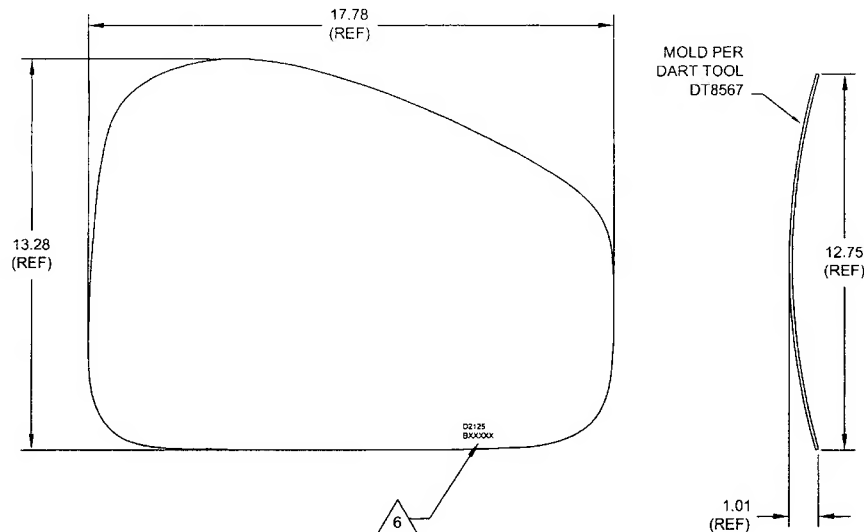
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D2125 FLOOR WINDOW
(FLAT TEMPLATE)

D2125 FLOOR WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2125" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 0.98 +/- 0.22 LBS
- 8) FLAT ROUGH SIZE: 13.3 x 17.8 x 0.13
- 9) MOLD PER DART TOOL DT8567

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86084 MLO

12/06/22

RELEASED
07.07.18

C	REDRAWN PER PAR 187	DC	07.07.18
B	CREATE DWG. UPDATE MTL PER NCR 029	MB	06.04.19
A	ADDED PICTURE WITH OVERALL DIMS	KE	99.03.09
-	NEW ISSUE	BW	92.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JB	DRAWING NO.	REV. C
MFG. APPR.	JB	D2125	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	350/355 FLOOR WINDOW	NTS.
DATE	07.07.18	COPYRIGHT © 1992 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	